Qty:

Each

: SPACER

: D32863

: N/A

: D3286 REV A

: 22/08/2008

Monday, 18/08/2008 10:21:49 AM

User:

Julie Lecoca

Process Sheet

Drawing Name

Part Number

Material

Due Date

Drawing Number

Project Number

Drawing Revision

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number** : 41272

Previous Run

P.O. Number

This Issue

: 18/08/2008

: 10692

Prsht Rev. : // First Issue

: NC

S.O. No. :

Type

: 37783

: MACHINED PARTS

Checked & Approved By Comment

Written By

: Est A 04.07.14

New issue KJ/JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

304 RD Tube .500 x .049W

1.0

M304TR0500W049

Comment: Qty.: 0.3588 f(s)/Unit

Total: 304 RD Tube .500 x .049W

Turn (2) D3286-3 per (1) skidtube assemblyDwg⁻D3286

Material: AISI 304/316 SS tubing 0.500" OD x 0.049" wall-

(M304TR0.500W.049)

Identify as D3286-3

Batch: Mc08324 HARDINGE CNC LATHE SMALL

2.0

HARDINGE

3.5879 f(s)



Comment: HARDINGE CNC LATHE SMALL

Turn blanks as per Folio FA434 and Dwg D3286

Deburr as [per Dwg D3286

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

- 5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:





Dart Ae	rospace L	.td							
W/O:			WORK ORDER O	CHANGES					
DATE	STEP	PRO		Ву	Date Q	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	:	PAR #:	Fault Category:	NCR	t: Yes	No DQ	A :	_ Date: _	· · · · · · · · · · · · · · · · · · ·
			·		QA: N	I/C Close	d:	Date: _	
NCR:		\	WORK ORDER NON-CON	FORMANCE	(NCF	₹)			
DATE	STEP	Description of NC	Corrective Action		Sign 8	Verific	ation	Approval	Approval

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B				Annecial			
DATE	STEP	Section A			Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector			
····											

NOTE: Date & initial all entries

Date:

Monday, 18/08/2008 10:21:49 AM

User: 1, Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 41272

Part Number: D32863

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0



FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
		•								
Part No		PAR #· Fault Category	NCP: Yes	No DO	۸۰	Date:				

Part No:	PAR #:	Fault Category:	NCR: Yes	No	DQA:	Date:
			QA: N	/C CI	osed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC	tion of NC Corrective Action Section B			Verification	A 1				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	41272
Description: Spacer	Part Number:	D3286-3
Inspection Dwg: D3286 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

		X First Article P			Prototype				
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method o		omments		
4.000	+/-0.010	4.007	-						
0.500	+/-0.010	.497							
				-					
	<u> </u>								
	<u> </u>								
				!		_			
					3.5				
			<u> </u>						
			-				· · ·		
<u>, , , , , , , , , , , , , , , , , , , </u>									
						· .			
	-								
									
Measured by:	4	Audited by:	- T		Prototype Approval: N				
Date:	08-09-03	Date:	080	40.5		Date:	N/A		
Rev Date	Change			•		Revised by	Approved		
A 04.09.01	New Issue					KJ/JLM	4 91		

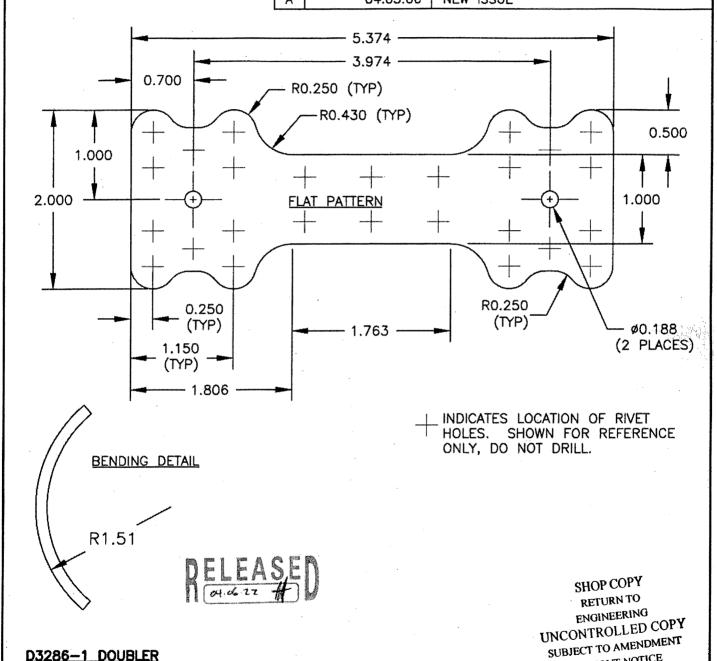




DESIGN	DRAWN BY	DART AF	ROSPACE	USA, INC.
U		DANI AL	PORT HADLOCK, 1	
CHECKED	APPROVED	DRAWING NO.		REV. A
ell-	#F	D3286		SHEET 1 OF 2
DATE		TITLE	· ·	SCALE:
04.05.06	}	GROUND HAN	DLING PARTS	1:1
 Δ	04.05.06	NEW ISSUE	•	

WITHOUT NOTICE

WORK ORDER



D3286-1 DOUBLER

1) MATERIAL: AISI 304/316 SS SHEET 0.125" THICK (REF DART SPEC. M304S11GA)

2) BREAK ALL SHARP EDGES 0.010 TO 0.020

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

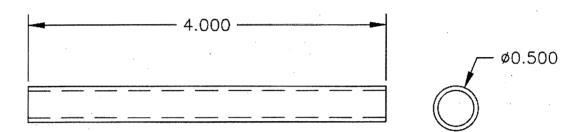
4) ALL DIMENSIONS ARE IN INCHES

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D3286-3 SPACER

1) MATERIAL: AISI 304/316 SS TUBING, 0.500 O.D. x 0.049 WALL (REF DART SPEC. M304TR0.500W.049)

2) BREAK ALL SHARP EDGES 0.010 TO 0.020

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES

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